

Date: Wednesday, 26/11/2008 12:45:43 PM.
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JACK SADDLE
Job Number : 43742	
Estimate Number : 11177	
P.O. Number :	Part Number : D2281
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D2281 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : G
Previous Run : 41888	Material :
Written By :	Due Date : 10/12/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JUL 08.11.26</u>	
Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS sheet .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total: 6.5625 sf(s)

304SS .080

batch: 109358 B 8-12-5

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: GProg Rev: GB 8-12-5(60)

2-Deburr if necessary

B 8-12-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-12-5**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK508/12/08 counter (+60)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** Deburru/k Done at step #22 5/8/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:45:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 43742

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB

09/01/15

60

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/01/15

countes

(x60)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MISC

SP 09-01-15
CPL 09-01-15

(x60)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/16

Job Completion



MF 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43742
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.470	✓			
4.114	+/-0.010	4.115	✓			
2.933	+/-0.010	2.935	✓			
1.535	+/-0.010	1.535	✓			
0.354	+/-0.010	.354	✓			
0.354	+/-0.010	.354	✓			
0.604	+/-0.010	.603	✓			
2.000	+/-0.010	1.999	✓			
3.396	+/-0.010	3.397	✓			
3.646	+/-0.010	3.644	✓			
4.000	+/-0.010	4.004	✓			
1.525	+/-0.010	1.527	✓			
2.475	+/-0.010	2.477	✓			
Ø0.323	+0.006/-0.001	.324	✓			
0.080	+/-0.010	Ø.083	✓			

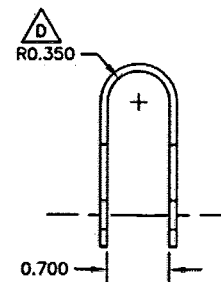
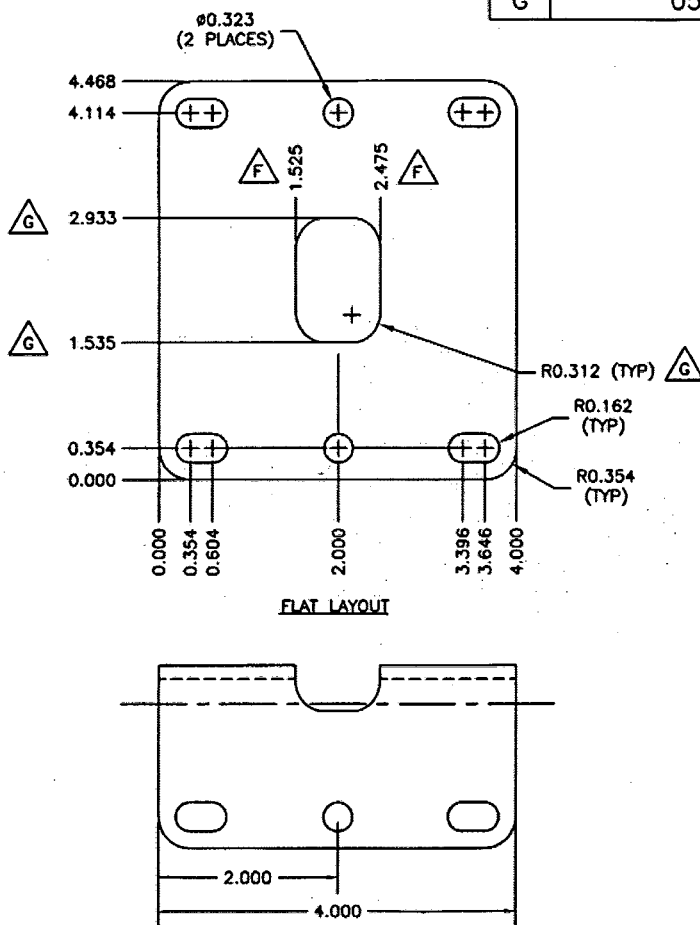
Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 8-12-8	Date: 08/12/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

DART**RELEASED**

05/08/11

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43742

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